

Work Order ID 73208

Friday, August 26, 2011 7:12:17 AM

ASAP



Page 1

Item ID: D412-785-002-401

Accept



Setup Start



Revision ID:

Stop



Item Name: Faceplate

Start Date: 8/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

CZ

Date: 11/08/26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D412-785-002-101

B

100

0.00

MAT NOT PULLED



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3065

Dwg Rev: B

Prog Rev: B

6061.003

2-Deburr as required

B11-8-29

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-8-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



S wlos/29



QC

Memo

0.00

Quality Control

130

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Deburr if necessary.



Count Sink as per Dwg.
11-08-30

0.00

EP 11/08/30



P/O

140

NC BRAKE

0.00

Brake NC

Memo

Brake NC

Bend as per Dwg D412-785-002

S 11/08/30



W/O: 73208		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-755-42-401 PAR #: _____ Fault Category: Small FAB NCR: Yes ☒ No ☐ DQA: ck Date: 11/09/08
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: ck Date: 11/09/08

NCR:		WORK ORDER NON-CONFORMANCE (NCR) 181.14						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.06.30	140	2 PARTS SCRAP, NEW PART; R.C. TRYOUT BEWIND.	11.06.30 Q51042	SCRAP + DESTROY. Do not REPAIR. Qty 2	JS 11/08/30	JS 11/08/31	JS 11/09/28	JS 11/09/31

NOTE: Date & initial all entries

Work Order ID 73208

Friday, August 26, 2011 7:12:17 AM



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Item ID: D412-785-002-401

Accept



Setup Start



Revision ID:

Stop



Item Name: Faceplate

Start Date: 8/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		S wlog 131		(2)			
151 Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: 114514 Memo Grind flush. E	0.00 0.00		11-09-31		2	φ		
152 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds QCW Memo	0.00 0.00		S wlog 101				P10 →	

W/O: 73208		Perm. <i>Chand</i>						WORK ORDER CHANGES			
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
11/29/01	#52	change step 6 QC inspection	E	11-09-02		<i>W</i>	<i>S</i> 11/29/01				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73208

Friday, August 26, 2011 7:12:17 AM



Page 4

Item ID: D412-785-002-401

Accept



Setup Start



Revision ID:

Stop



Item Name: Faceplate

Start Date: 8/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

153

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulog 01

P/b →

180

Identify as per dwg & Stock Location: 0.00

0.00



Packaging

Memo

0.00

Packaging

Sp 11-09-01

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/01

MF 11-09-01

W/O: 73008		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/08/11	# 154	ADD Step for the chemical coat. per QST005	BA	11-09-11	2	h	S 11/09/11	
11/08/11	# 155	QC 3 inspect chemical coat	M. 11/09/11	11/09/11	2X	h	S 11/09/11	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 7:12:14 AM

Page 1

Work Order ID: 73208

Parent Item: D412-785-002-401

Parent Item Name: Faceplate



Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-08-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

sf

283.1256

2.947368

6.



BU-8-29

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

283.1255684

116308

26.9755684

117285

111.15

118580

145

117285

④

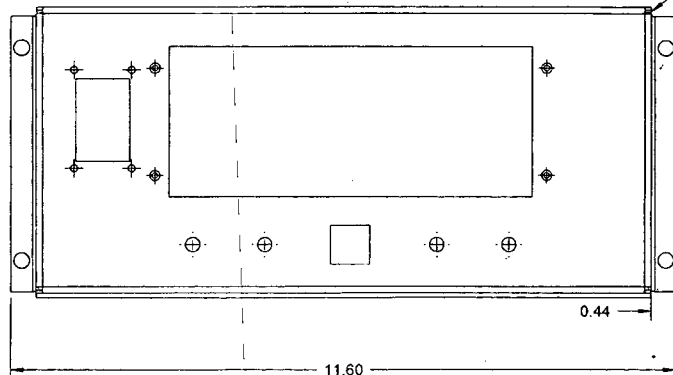
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

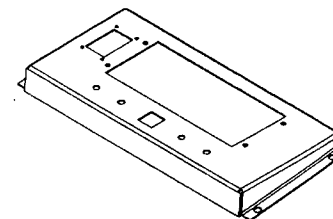
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

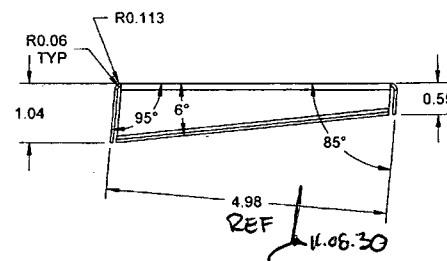


D412-785-002-401 FACE PLATE
MADE FROM D412-785-002-401F



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73208

CZ11/08/26

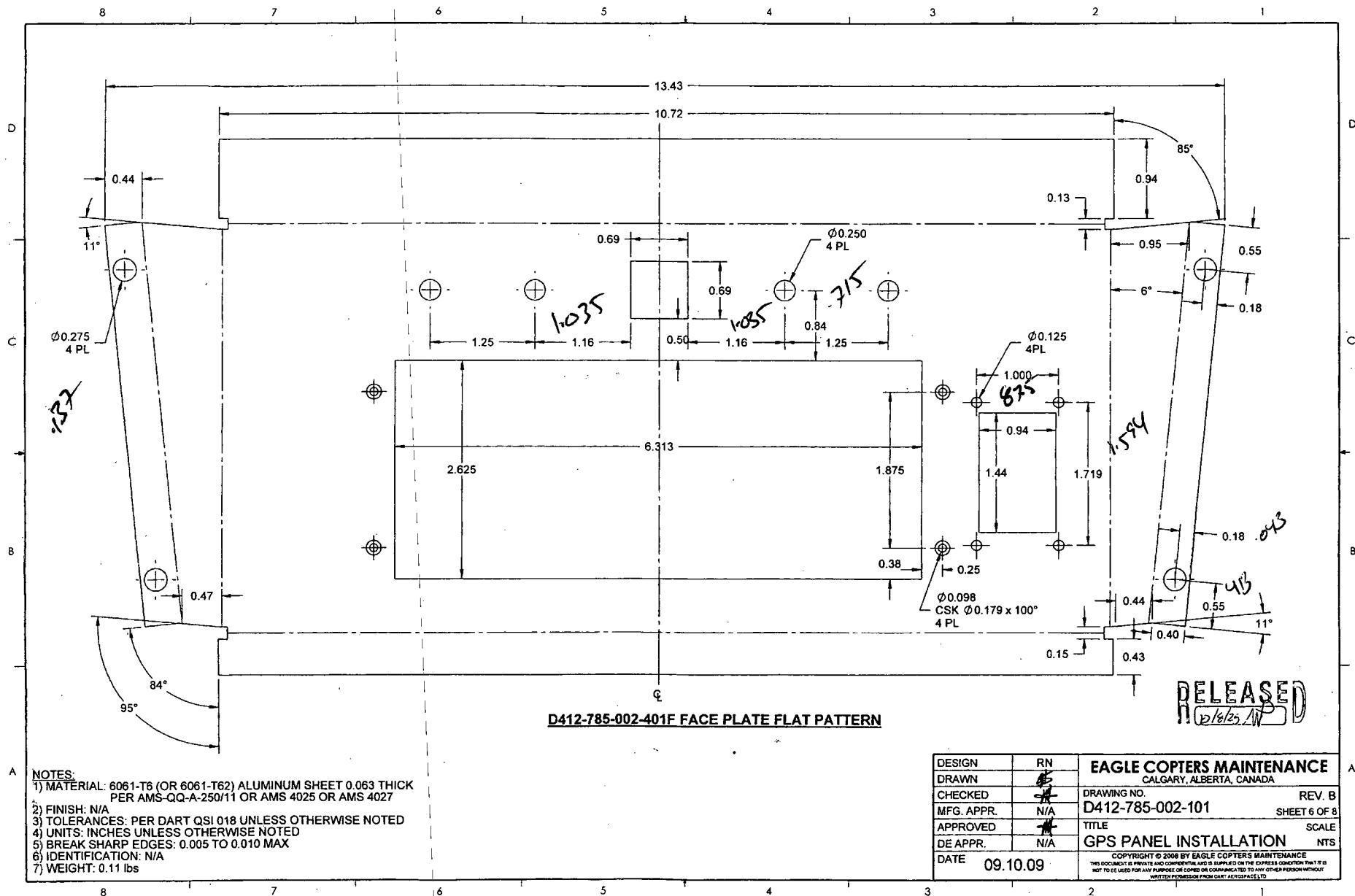


RELEASED
10/1/25

NOTES:

- 1) MATERIAL: MADE FROM D412-785-002-401F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs
- 8) WELD PER DART QSI 004

DESIGN		EAGLE COPTERS MAINTENANCE	
DRAWN	RN	CALGARY, ALBERTA, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	D412-785-002-101	SHEET 5 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	GPS PANEL INSTALLATION	NTS
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DART AEROSPACE LTD		Work Order: 73208
Description: FACE PLATE		Part Number: D412-785-002-401
Inspection Dwg: D412-785-002-401	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	✓		✓ 1B02	
Ø .125	+ .004 - .001	.126	✓		✓	
Ø .250	+ .005 - .001	.250	✓		✓	
Ø .275	+ .006 - .001	.275	✓		✓	
B.43	± .030	13.43	✓		✓ 1B02	
10.72	± .030	10.722	✓		✓ ProwSe2	
.94	± .030	.942	✓		✓	
.13	± .030	.130	✓		✓	
.55	± .030	.544	✓		✓	
.18	± .030	.185	✓		✓	
.43	± .030	.436	✓		✓	
.15	± .030	.149	✓		✓	
1.719	± .010	1.718	✓		✓	
1.006	± .010	.997	✓		✓	
.94	± .030	.937	✓		✓	
1.44	± .030	1.431	✓		✓	
.25	± .030	.249	✓		✓	
.38	± .030	.383	✓		✓	
1.875	± .010	1.873	✓		✓	
2.625	± .010	2.622	✓		✓	
6.313	± .010	6.313	✓		✓	
.69	± .030	.691	✓		✓	
.50	± .030	.500	✓		✓	

Measured by: IB
Date: 11-8-29

Audited by: S
Date: 11/08/29

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

